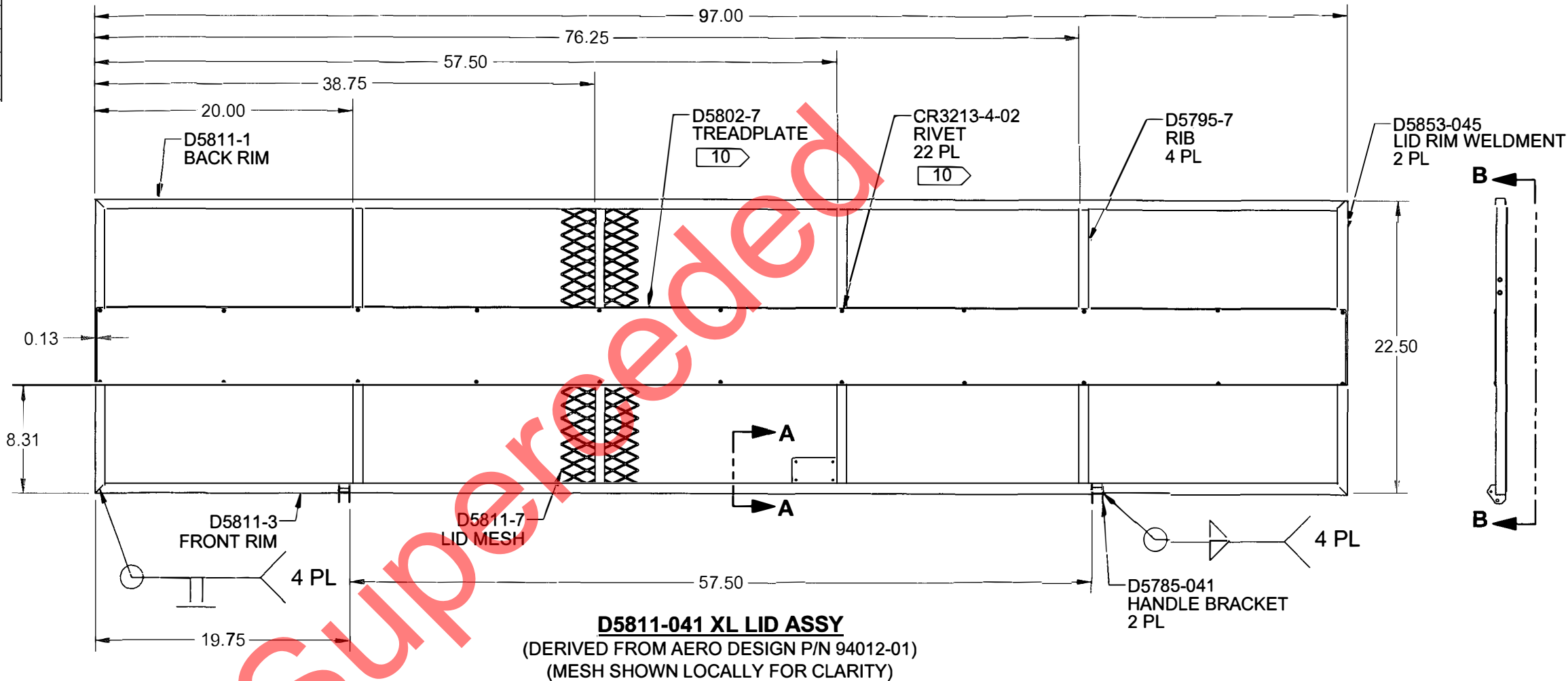


QTY -041	P/N	DESCRIPTION
X	D5811-041	XL LID ASSY
2	D5785-041	HANDLE BRACKET
4	D5795-7	RIB
6	D5795-11	STRINGER
1	D5795-15	PLACARD BRACKET
1	D5802-7	TREADPLATE
1	D5811-1	BACK RIM
1	D5811-3	FRONT RIM
4	D5811-5	STRINGER
1	D5811-7	LID MESH
2	D5853-045	LID RIM WELDMENT
22	CR3213-4-02	RIVET



SECTION A-A  
SCALE 2.5X

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3.
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
  - 7) WEIGHT: 23.43 lbs
  - 8) WELD PER DART QSI 004. IT IS PERMISSIBLE TO GRIND OR BUFF TO CLEAN UP WELDS
  - 9) DRILL #30 ( $\phi 0.129$ ) VENT HOLES AS REQUIRED. FILL ALL EXPOSED VENT HOLES WITH ROSETTE WELD PRIOR TO FINISH.
  - 10) INSTALL TREADPLATE AFTER FINISH. TRANSFER MARK AND DRILL HOLES  $\phi 0.129 +0.003/-0.000$  FROM TREADPLATE TO LID. FAY SEAL SURFACES BETWEEN LID AND TREADPLATE WITH RTV SILICONE. SECURE TREADPLATE WITH RIVETS.
  - 11) WELD EVERY MESH INTERSECTION ALONG RIM.
  - 12) FOR EACH RIB, WELD FIRST 5 MESH INTERSECTIONS DOWN EACH END THEN EVERY 2ND MESH INTERSECTION MINIMUM.
  - 13) FOR EACH STRINGER, WELD EVERY 2ND MESH INTERSECTION MINIMUM.
  - 14) ALIGN STRINGERS TO TOP OF LID.
  - 15) LOCATE D5795-15 PLACARD BRACKET FLUSH WITH BOTTOM OF LID. TRIM MESH TO CLEAR BRACKET LEAVING 0.25 OVERLAP. WELD MESH TO BRACKET.

RELEASED

2020 FEB 19  
ECN 2020-524

UNDER REVIEW  
ECR: HB ECR 132

APPROVED

A	NEW ISSUE	ZF	20.01.21
REV.	DESCRIPTION	BY	DATE
DESIGN	ZF		
DRAWN	ZF		
CHECKED	KPT		
MFG. APPR.	DD		
APPROVED	NO		
DE APPR.	CP		
DATE	20.01.21		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO. D5811			
TITLE XL LID ASSY			
REV. A			
SHEET 1 OF 5			
SCALE NTS			
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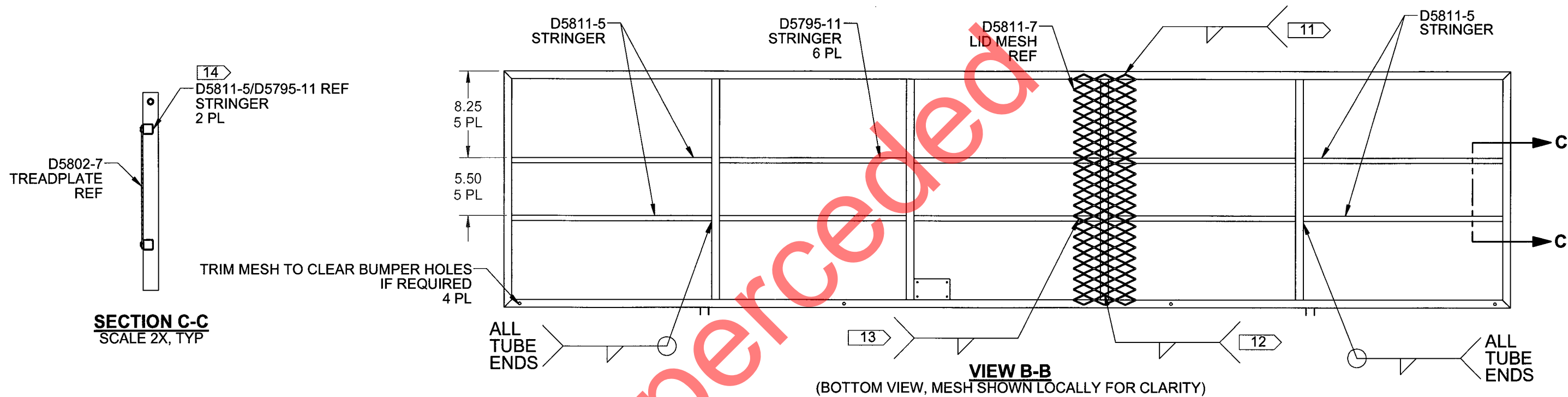
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UNDER REVIEW  
ECR: HB ECR 132

RELEASED

2020 FEB 19 *q*

APPROVED

DESIGN ZF  
DRAWN ZF  
CHECKED KPT  
MFG. APPR. DD  
APPROVED NO  
DE APPR. CP  
DATE 20.01.21

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D5811** REV. A  
TITLE **XL LID ASSY** SHEET 2 OF 5  
SCALE NTS

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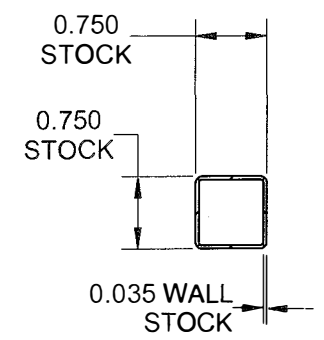
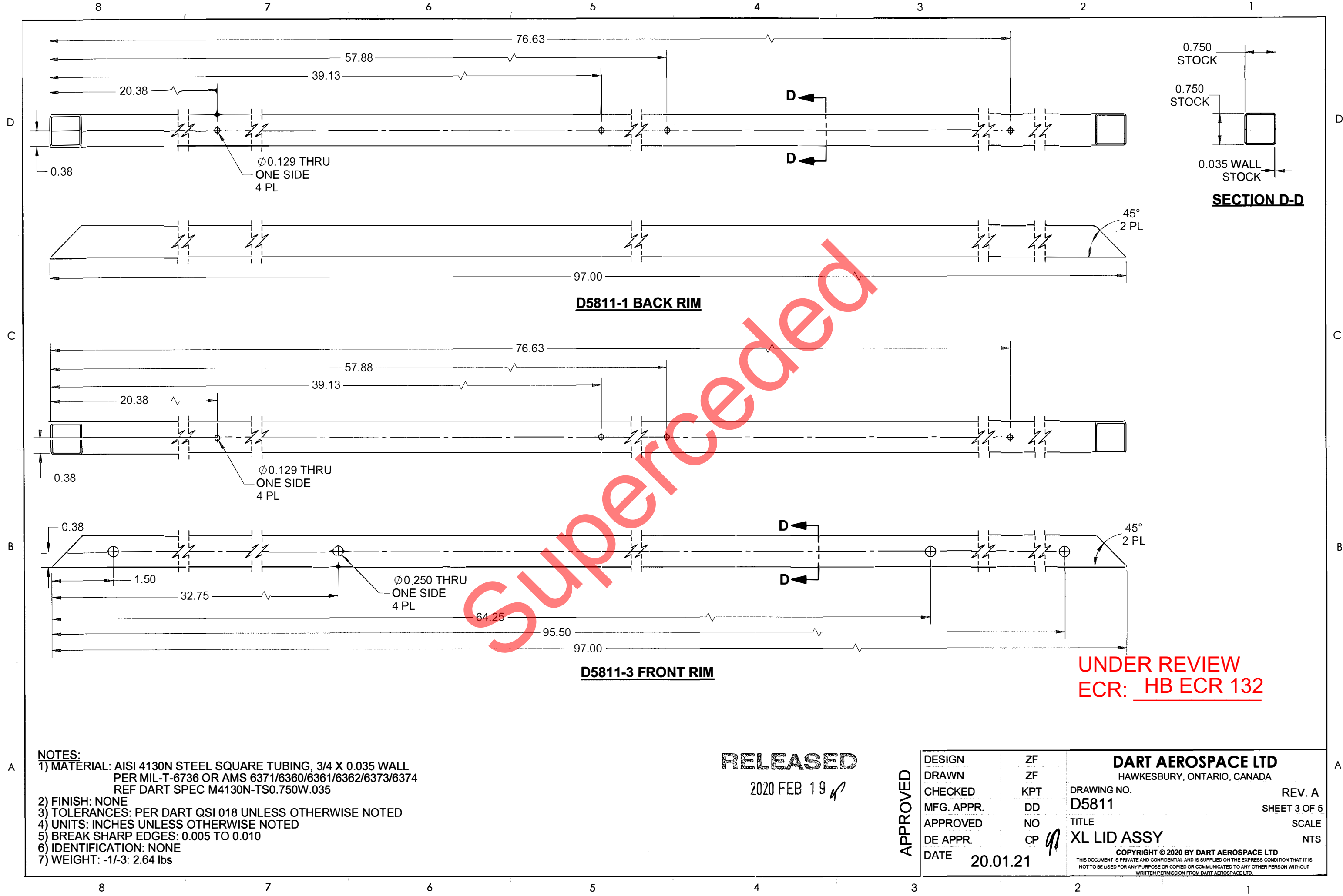
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SECTION D-D

D5811-1 BACK RIM

D5811-3 FRONT RIM

UNDER REVIEW  
ECR: HB ECR 132

- NOTES:
- 1) MATERIAL: AISI 4130N STEEL SQUARE TUBING, 3/4 X 0.035 WALL PER MIL-T-6736 OR AMS 6371/6360/6361/6362/6373/6374 REF DART SPEC M4130N-TS0.750W.035
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: -1/-3: 2.64 lbs

RELEASED  
2020 FEB 19

APPROVED

DESIGN	ZF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ZF		
CHECKED	KPT	DRAWING NO.	REV. A
MFG. APPR.	DD	D5811	SHEET 3 OF 5
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	XL LID ASSY	NTS
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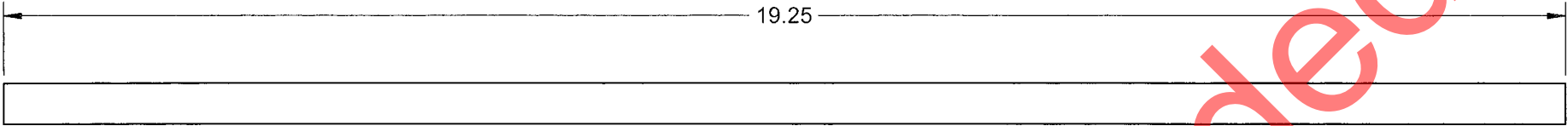
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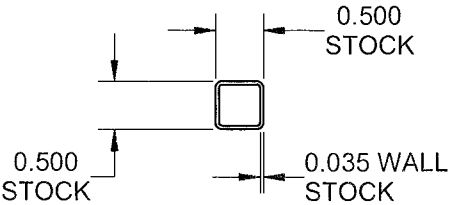
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**D5811-5 STRINGER**



Superceded

UNDER REVIEW  
ECR: HB ECR 132

- NOTES:
- 1) MATERIAL: AISI 4130N STEEL SQUARE TUBING, 1/2 X 0.035 WALL  
PER MIL-T-6736 OR AMS 6371/6360/6361/6362/6373/6374  
REF DART SPEC M4130N-TS0.500W.035
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.34 lbs

RELEASED  
2020 FEB 19 *up*

APPROVED

DESIGN	ZF
DRAWN	ZF
CHECKED	KPT
MFG. APPR.	DD
APPROVED	NO
DE APPR.	CP <i>up</i>
DATE	20.01.21

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.  
**D5811**

TITLE  
**XL LID ASSY**

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REV. A  
SHEET 4 OF 5  
SCALE  
NTS

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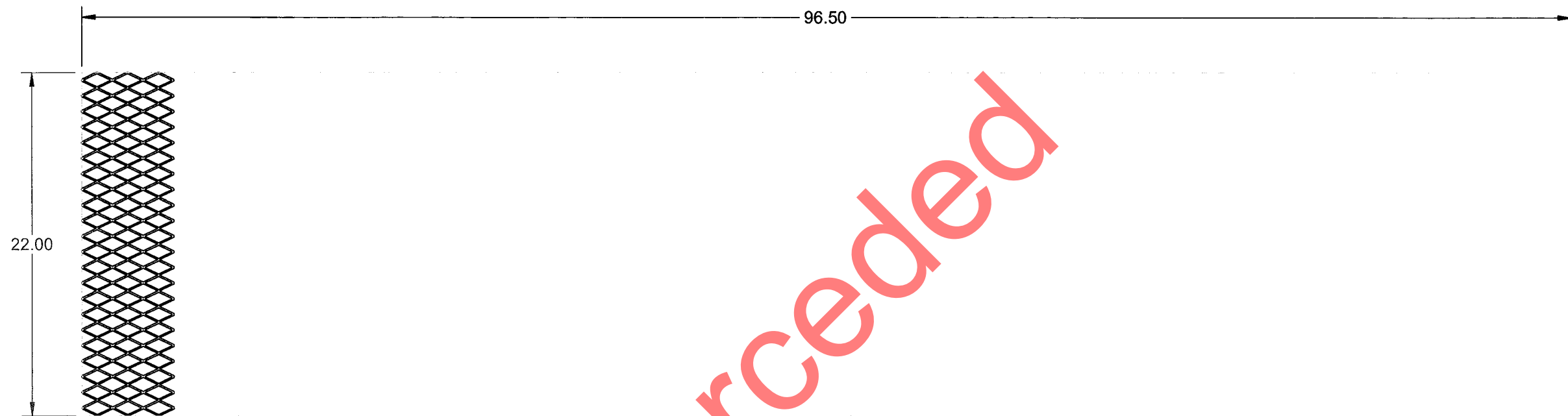
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**D5811-7 LID MESH**  
(MESH SHOWN LOCALLY FOR CLARITY)

Superceded

UNDER REVIEW  
ECR: HB ECR 132

- NOTES:
- 1) MATERIAL: CARBON STEEL EXPANDED METAL MESH 3/4-16F  
PER ASTM F1267 OR MIL-M-17194D  
REF DART SPEC M569EX0.75-16F
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 7.75 lbs

RELEASED

2020 FEB 19 *41*

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DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	DRAWING NO.	REV. A
MFG. APPR.	DD	<b>D5811</b>	SHEET 5 OF 5
APPROVED	NO	TITLE	SCALE
DE APPR.	CP <i>41</i>	<b>XL LID ASSY</b>	NTS
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